



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
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Tel (613) 632-5200

RBEA62309
Job Sheet 170533



00 2066

Part No: RBEA62309

Job Qty: 1 ea

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBEA62309 rev.12 IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea		2/15/18			DAR001-VU		MCC
110	Small Fab	1 pcs		2/16/18	0.00	1.00	Small Fab-9		MCC DAS 38
120	QC	1 pcs		2/16/18	0.00	0.00	QC5		SmrB
130	Packaging	1 pcs		2/16/18	0.00	0.00	Packaging3-2		
140	QC21-FG	1 Ea		2/16/18	0.00	0.00	QC21		

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case 7- See note 1 for hoses

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Start up Operation	97524A032	4	259	0	0
	APP-1700-E	1	0	0	0
	RB41011	1	955	0	0
	RBE-350DAMPER 5048091	1	0	0	0
	RBE-350HYD 6051027	1	0	0	0
	RBE-350INCLINOMETER	1	0	0	0
	RBE-350TDRS	1	2	0	0
	RBE-350TEMP 5045008	1	0	0	0
	RBE350A93-3200-20	1	0	0	0
	RBE350A93-3205-00E	1	0	0	0
	RBE350A93-3205-00T	1	0	0	0
	RBE350A93-3300-20	1	0	0	0
	RBE350A93-3302-02	1	0	0	0
	RBE350A93-3303-02	1	0	0	0
	RBE350A93-3305-20	1	0	0	0
	RBE350A93-3307-00	1	0	0	0
	RBE350A93-3312-03	1	0	0	0
	RBE350A93-3316-20	1	0	0	0
	RBE350A93-3317-20	1	0	0	0
	RBE350A93-3400-00	1	0	0	0
	RBE350A93-3500-00	1	0	0	0
	RBE350A93-3501-20	1	0	0	0
	RBE350A94-2704-00	1	0	0	0
	RBE350A94-2706-00	1	0	0	0
	RBE350A94-2708-01	1	0	0	0
	RBE350A94-3301-00	1	0	0	0
	RBE350A94-3700-A	1	0	0	0

DAS
03
8-38

RBE350A94-3700-C	1	0	0	0
RBE350A94-3701-00	1	0	0	0
RBE350A94-5201-20	1	0	0	0
RBE703A94-1130-01	1	0	0	0
RBE703A95-0505-00	1	0	0	0
RBE703A95-0508-00	1	2	0	0
RBE703A95-0520-01	1	0	0	0
RBE703A95-0520-01-11	1	0	0	0
RBE703A95-0520-01-13	1	0	0	0
RBE703A95-0520-01-15	1	0	0	0
RBEA62309-65	1	0	0	0
RBEA62309-81	1	0	0	0
RBEA62309-83	1	0	0	0
RBEA62310	1	0	0	0
RBT18025-13	1	0	0	0
RBW109-3101-58-1-1	1	0	0	0
RBW109-3101-58-2-1	1	0	0	0

Part Specifications

Specifications could not be found.

Plex 1/17/18 8:58 AM Dart.lajeunesse.marie



Container No: S056914



Part: RBEA62309

Serial No/Batch: S056914
Revision: 12
Inspector:

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Date: 03/29/18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170533M

1 7 FT. HOSES MUST COUPLE IN CUTOUT. MIN TRIM ACCEPTABLE.

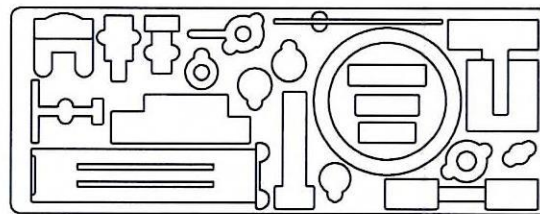
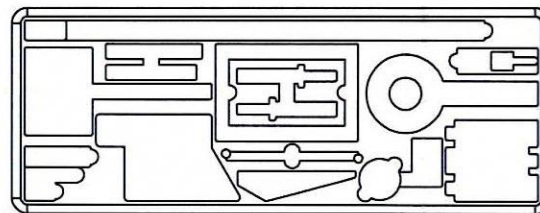
		REV	
		12	
TITLE			
AS350-355 FIELD MAINTNANCE KIT			
DWG NO.		RBEA62309	
MATERIAL		UNLESS OTHERWISE SPECIFIED	
NEXT DAY		DIMENSIONS ARE IN INCHES	
FINISH		FRACTIONS $\frac{1}{16}$	
SPEC		ANGLES 45°	
		SURFACES $\sqrt{16}$	
DRAWN BY: CLOUGH		1. BREAK ALL SHARP EDGES $\cdot 015 \times 45^\circ$ OR $\cdot 015R$	
CHECKED: DUERFELDT		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
COP'S APPR: ANDERSON		3. DIMENSIONAL DIM AND TOL PER ASME Y14.5M-2009	
DIA APPR: LINDSAY		4. USED ON MODEL	
APPROVED: GILBERT		AS350/355	
SCALE 1:8		DATE 9/20/2016	
		SHEET 1 OF 8	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
11	16-0149	ADDED RBW109-3101-58-1 & RBW109-3101-58-2 TO BOM. -43 RBE-RDG-15 REPLACED W/ RBT18025-13.	9/21/2016	RJC	JAG
12	17-0013	CHD B/O INFO WAS RBE703A95-0250-01 & RBE703A95-0250-01 -1, -11, -13, -15, WAS RBW109-3101-58-1 IS RBW109-3101-58-1-1, WAS RBW109-3101-58-2 & RBW109-3101-58-2-1: CHD DESCRIPTION WAS ENGINE & HYDRAULIC DRAIN TUBE & ENGINE & HYDRAULIC; -77 CHD QTY WAS 1 & 4.	1/24/2017	SM	JAG

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			1		DAMPER SPANNER WRENCH		RBE-350DAMPER	1
			1		HYD. ACCUMULATOR FITTING GAUGE		RBE-350HYD	1
			1		T/R DRIVESHAFT BEARING RUNOUT GAUGE		RBE-350TROD	1
			1		MGB/ROTOR BRAKE RETAINING NUT WRENCH		RBE350A93-3200-20	1
			1		T/R G/B INPUT FLANGE HOLDING WRENCH		RBE350A93-3205-00T	1
			1		ENGINE G/B INPUT FLANGE HOLDING WRENCH		RBE350A93-3205-00E	1
			1		T/R HUB SOCKET		RBE350A93-3300-20	1
			1		T/R HUB LOCK WRENCH		RBE350A93-3303-02	1
			1		T/R BODY EXTRACTOR TOOL		RBE350A93-3303-02	1
			1		TAIL GEARBOX WRENCH		RBE350A93-3305-20	1
			1		TAIL GEARBOX SEAL EXTRACTOR		RBE350A93-3307-00	1
			1		T/R HUB BUSHING REPLACEMENT TOOL		RBE350A93-3312-03	1
			1		ROTATING STAR REPLACEMENT WRENCH		RBE350A93-3316-20	1
			1		TAIL ROTOR HUB INSERT TOOL		RBE350A93-3317-20	1
			1		DRIVE SHAFT THIMBLE		RBE350A93-3400-00	1
			1		BEARING EXTRACTOR		RBE350A93-3500-00	1
			1		EXTRACTION TOOL HYD. PUMP PULLEY BEARING		RBE350A93-3501-20	1
			1		M/R BLADE TRIM TAB TOOLS		RBE703A94-1130-01	1
			1		JAMMING TOOL, PEDALS		RBE350A94-2704-00	1
			1		RIGGING PIN SET		RBE350A94-2706-00	1
			1		T/R BLADE LOCK FIXTURE		RBE350A94-2708-01	1
			1		T/R ACCELERATOR SUPPORT		RBE350A94-3301-00	1
			1		SWASHPLATE IMMOBILIZING TOOL LONG BRACE		RBE350A94-3700-A	1
			1		SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE		RBE350A94-3700-C	1
			1		M/R RIGGING TOOL		RBE350A94-3701-00	1
			1		CARTRIDGE, DUMMY, FUEL		RBE350A94-5201-20	1
			1		ENGINE & HYDRAULIC		RBE703A95-0520-01 -1, -11, -13, -15	1
			1		TGB DRAIN TUBE		RBE703A95-0505-00	1
			1		MGB DRAIN TUBE		RBE703A95-0508-00	1
			1		LINEAR SCALE		RBT18025-13	1
			1		AS350/355 ENGINE STRUT		RBEA62310	1
			1		HAMMER, STEEL		RBW109-3101-58-1-1	1
			1		HAMMER, ALUMINUM		RBW109-3101-58-2-1	1
			1		INCLINOMETER		RBE-350INCLINOMETER	1
			1		TEMPERATURE PROBE		RBE-350TEMP	1
		-65	1		LAMINATED LOCATION CARD	LAMINATED CARD		6
		B/O	-67	1	LANYARD	COATED STEEL	Ø1/16 X 12 CARR LANE #CL-2-C	N/S
		B/O	-69	1	GROMMET	NICKEL-PLATED BRASS	SIZE 00, Ø.42 OD (MCMMASTER-CARR #84625K31)	N/S
		B/O	-71	1	EYELET	COATED COPPER	SIZE 2 (CARR-LANE #CL-194-TERM-2)	N/S
		B/O	-73	4	RIVET	ALUMINUM	Ø3/16 X 3/8 - 1/2 (MCMMASTER-CARR #97526A421)	N/S
		B/O	-75	1	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMMASTER-CARR #3896131)	N/S
		B/O	-77	4	ELASTIC RETAINER W/HOOKS	BUNGEE CORD	Ø1/4 X 10in.	1
		B/O	-79	1	HARD CASE	PLASTIC	PELICAN #APP-1700-E	N/S
		B/O	-81	1	TOP SHELF CUSHION	ETHAFOAM 220, BLACK	1.81 X 13-5/8 X 35-5/8 (CASE SOLUTIONS)	3 & 4
		B/O	-82	1	TOP CUSHION STIFFENER	COROPLAST, BLACK	6mm X 13-5/8 X 35-5/8 (CASE SOLUTIONS)	5
		B/O	-83	1	BOTTOM SHELF CUSHION	ETHAFOAM 220, BLACK	3-1/4 X 13-5/8 X 35-5/8 (CASE SOLUTIONS)	6 & 7
		B/O	-87	1	REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	1
		B/O	-89	1	CABLE TIES	NYLON	(MCMMASTER-CARR #7189K31)	1
		B/O	-91	1	VIAL FOR FLANGE WRENCH BOLTS	POLYPROPYLENE	Ø2.03 O.D. X 1.58in. (MCMMASTER-CARR #5274761)	1
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S

← 5038430



DART AEROSPACE	
TITLE AS350-355 FIELD MAINTENANCE KIT	
DWG NO. RBEA62309	REV 12
MAT'L _____ FINISH _____ SPEC _____ DRAWN BY: CLOUGH CHECKED: DUERFELDT OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES ± 125 1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:1	DATE 9/20/2016
SHEET 2 OF 8	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								